

Work Order ID 69918

Tuesday, May 24, 2011 2:18:36 PM



Page 1

Item ID: D2938-1

Accept



Setup Start



Revision ID:

Item Name: Saddle LH Out, 206

Stop



Start Date: 5/24/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-05-24

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2938	Rev C

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

RR 11.7.8

6

HAAS CNC vertical machine #1

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

RR 11.7.8

6

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

RR 11.7.8

6

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D2938-1

Accept



Setup Start



Revision ID:

Item Name: Saddle LH Out, 206

Stop



Start Date: 5/24/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC8- Inspect parts - second check 0.00

2 11/07/11



QC Memo 0.00

Quality Control

6

140 Chemical Conversion Coat per QSI005 4.1 0.00



HandFinish Memo 0.00

Hand Finishing

6 x BL 11-7-11

150 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00



Powdercoat Memo 0.00

Powder Coating

START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME: _____

2:10

2:40

6 x M-L 11/07/11

M117 745 3200F

W/O:		WORK ORDER CHANGES					
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Work Order ID 69918



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Item ID: D2938-1 Accept  Setup Start 
Revision ID:
Item Name: Saddle LH Out, 206 Stop 
Start Date: 5/24/2011 Start Qty: 6.00  Cust Item ID:
Required Date: 5/31/2011 Req'd Qty: 6.00  Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160	QC3- Inspect Part Finish	0.00							
									
QC	Memo	0.00							
Quality Control									

170	Identify as per dwg & Stock Location: <u>429</u>	0.00							
									
Packaging	Memo	0.00							
Packaging									

180	QC21- Final Inspection - Work Order Release	0.00							
									
QC	Memo	0.00							
Quality Control									

11/7/12 
ME 11-07-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, May 24, 2011 2:18:42 PM

Page 1

Work Order ID: 69918

Parent Item: D2938-1

Parent Item Name: Saddle LH Out, 206




Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B ☐ 00.06.26 ☐ New DWG rev (mpp 2069) ☐ EC
IPP Rev: C As per Rev C 07-03-19 JLM ☐ ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003  Saddle Billet, 7075		Manufactured	No			100	Each	24.0000	1	6			

Handwritten: 11.7.8

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT040	14	
68171	14	
MAT45	10	
68172	10	

Handwritten: 70978

Handwritten: 6

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 69918
Description: 206 Saddle, Outboard, Left side	Part Number: D2938-1
Inspection Dwg: D2938 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions				5	6
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.136	.136	.136	.136	.136	.136
B	0.100	0.140		.132	.132	.132	.132	.132	.132
C	0.100	0.140		.120	.120	.120	.120	.120	.120
D	0.210	0.230		.220	.220	.220	.220	.220	.220
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		.511	.511	.511	.511	.511	.511
I	1.572	1.582		1.577	1.577	1.577	1.577	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		.257	.257	.257	.257	.257	.257
L	0.312	0.317		.313	.313	.313	.313	.313	.313
M	0.235	0.240		.238	.238	.238	.238	.238	.238
N	0.100	0.140		.109	.109	.109	.109	.109	.109
O	0.540	0.560		.552	.552	.552	.552	.552	.552
P	0.490	0.510		.502	.502	.502	.502	.502	.502
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720	3.720
R	2.720	2.760		2.743	2.743	2.743	2.743	2.743	2.743
S	0.240	0.270		.250	.250	.250	.250	.250	.250
T	0.100	0.180		.130	.130	.130	.130	.130	.130
U	1.625	1.635		1.630	1.630	1.630	1.630	1.630	1.630
V	1.362	1.372		1.367	1.367	1.367	1.367	1.367	1.367
W	0.316	0.321		.316	.316	.316	.316	.316	.316
X	1.250	1.270		1.260	1.260	1.260	1.260	1.260	1.260
Y	1.565	1.585		1.573	1.573	1.573	1.573	1.573	1.573
Z	0.178	0.198		.188	.188	.188	.188	.188	.188
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <u>RP</u>
Date: <u>11-4-8</u>

Audited by: <u>SL</u>
Date: <u>11/6/11</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

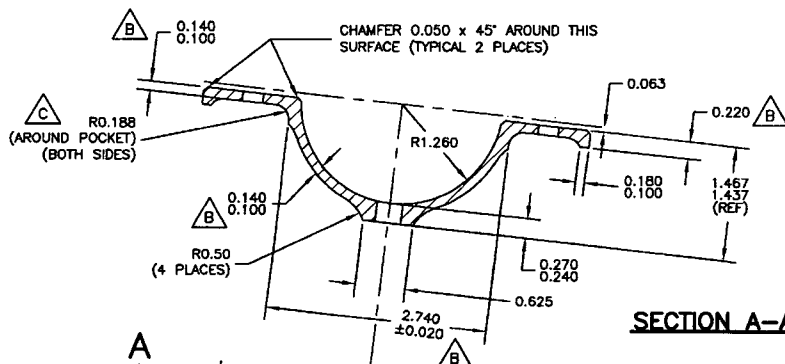
W/O:		WORK ORDER CHANGES					
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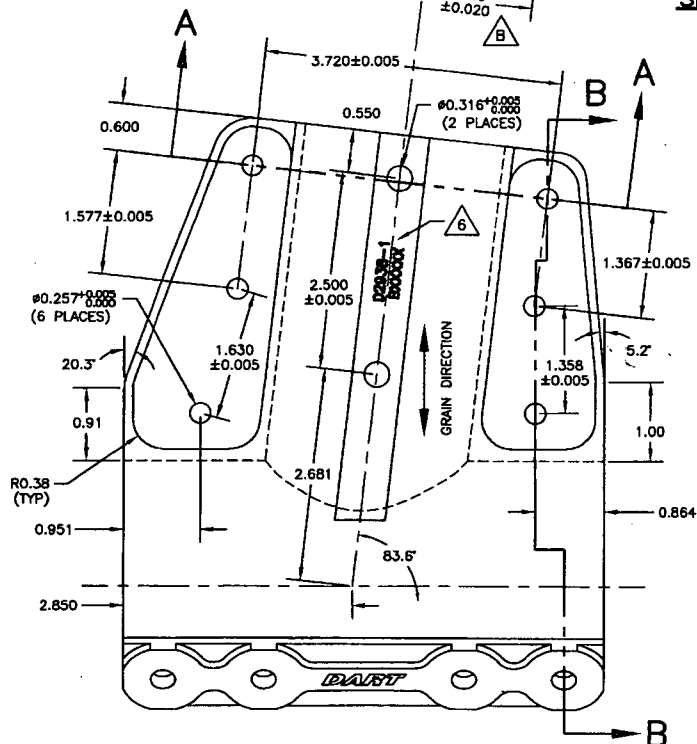
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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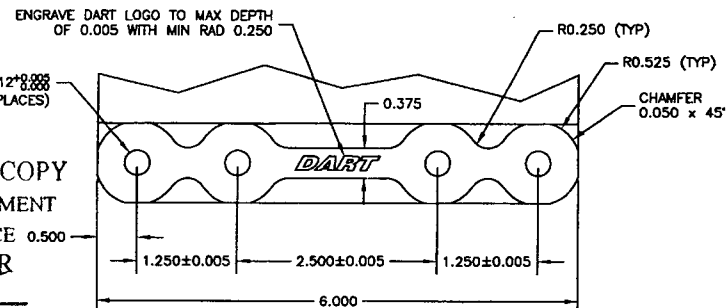


SECTION A-A



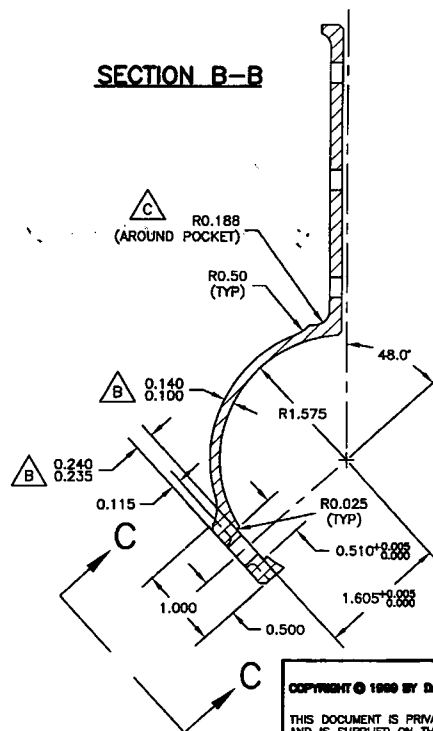
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 09918

011-05-24



VIEW C-C

SECTION B-B



D2938-1 LH SADDLE (SHOWN)
D2938-2 RH SADDLE (OPPOSITE)

- NOTES:
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	4	DRAWN BY
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE OUTSIDE
		SCALE
		2:3

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DART AEROSPACE USA, INC.

DART DART AEROSPACE USA, INC.
BELLINGHAM, WA

DRAWING NO.
D2938

REV. C
SHEET 1 OF 1

07.02.12

W/O:		WORK ORDER CHANGES					
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